Work Order ID 50952

July 28, 2009 8:41:49 AM

Page 1

Item ID:

D2891-1

A1

Revision ID: Item Name:

2.25 Support

Start Date:

07/29/2009

Start Qty: 20.00

Required Date: 08/28/2009

Req'd Qty: 20.00

Accept



Setup Start

Stop



Reference:

Approvals:

Process Plan:

Date:

Date: 09-07-28 Tooling:

Date:

Cust Item ID:

Customer:

Draw

Number

Start



QC:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID Operation **Description**

Set Up/ **Run Hours**

Draw Rev.

Plan Code

Reject Accept Qty Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D2891 Rev A1

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo Machine as per Folio FA046[]Tumble & Deburr

20

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

20

120

QC

QC8- Inspect parts - second check

Memo

0.00

Memo

D.A 09/08/06

20

Quality Control

Dart Aerospace Ltd	ace Ltd
--------------------	---------

W/O:		WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector						
Part No		DAD #. Foulk Cotomonia	NOD: Va			D - 4 -	L.						

I								l.,
Part No:		PAR #:	Fault Category:	NCR: Yes	No I	DQA:	Date: _	
	Resolution: _	·	Disposition:	QA: N/C	Closed:		_ Date: _	

NCR:			WORK OR	DER NON-CONFORMANCI	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Annyous	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
			· Kanada					
			·					
<u>,,</u>	<u> </u>							
					3			
	·							
 .								
						,		
	<u> </u>						,	

Work Order ID 50952

July 28, 2009 8:41:49 AM

Item ID:

D2891-1

A1

Revision ID: Item Name:

2.25 Support

Start Date:

07/29/2009

Start Qty: 20.00



Accept

Run

Setup Start

Stop



Required Date: 08/28/2009

Req'd Qty: 20.00

Date: _____ SPC (Y/N):

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

0.00

Tooling:

Date:

Stop

Start



Sequence ID/ Work Center ID

130

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Set Up/ **Run Hours**

Draw Number

Draw Rev.

Plan Code

Accept Qty

Reject Reject Qty

Insp. Number Stamp

M112260

0.00

Memo 7.30 OVEN TEMPERATURE: START TIME: & 100 AUTIFINISH TIME:

400F

09-00-10



140

Quality Control

QC3- Inspect Part Finish

Memo

Memo

0.00

0.00



150

Packaging Packaging

Identify as per dwg & Stock Location:

0.00

0.00



Dart	Aeros	pace	Ltd
------	-------	------	-----

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES											
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
			:											
					·									
							·							
Part No	:	PAR #: PAR #: NC	R: Yes	No DQ	A:	Date: _	·							

NCR:		,	DER NON-CONFORMANC	NFORMANCE (NCR)						
		Description of NC		Corrective Action Section B		Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Sign & Date		Section C	Chief Eng	QC Inspector		
		•								
		·								

Work Order ID 50952

July 28, 2009 8:41:49 AM

Page 3

Item ID:

D2891-1

Revision ID: A1

Item Name:

2.25 Support

Start Date:

07/29/2009

Start Qty: 20.00

Required Date: 08/28/2009

Req'd Qty: 20.00

QC21- Final Inspection - Work Order Release



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

Date:

SPC (Y/N):

Accept

Set Up/

Date:

Date:

Run

Start

Stop

Stop



Sequence ID/

Work Center ID

160

QC Quality Control

Memo

0.00

0.00

Run Hours

Number

Draw

Draw Rev.

Plan Code

Accept Qty

Reject Qty

Setup Start

Reject Number Stamp

Insp.

MJ 09-08-17 A

Dart Aerospace I	Ltd
------------------	-----

W/O:			14/01				· · · · · · · · · · · · · · · · · · ·						
		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHAN	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
							• ,						
		·											
Part No:		PAR #:	PAR #: Fault Category:						Date:				
Resolution:			Disposition: QA			QA: N/C Closed: Date:							
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR							
DATE	STEP	Description of NC Section A			Section B iption Sign & Date			ation on C	Approval Chief Eng	Approval QC Inspector			
			Office Ling	Chief Eng									
		·											
i													
ı													

Picklist Print

July 28, 2009 8:41:49 AM

Work Order ID: 50952

Parent Item:

D2891-1RevA1

Parent Item Name: 2.25 Support

Comments:

Start Date: 07/29/2009

Required Date: 08/28/2009

Start Qty: 20.00

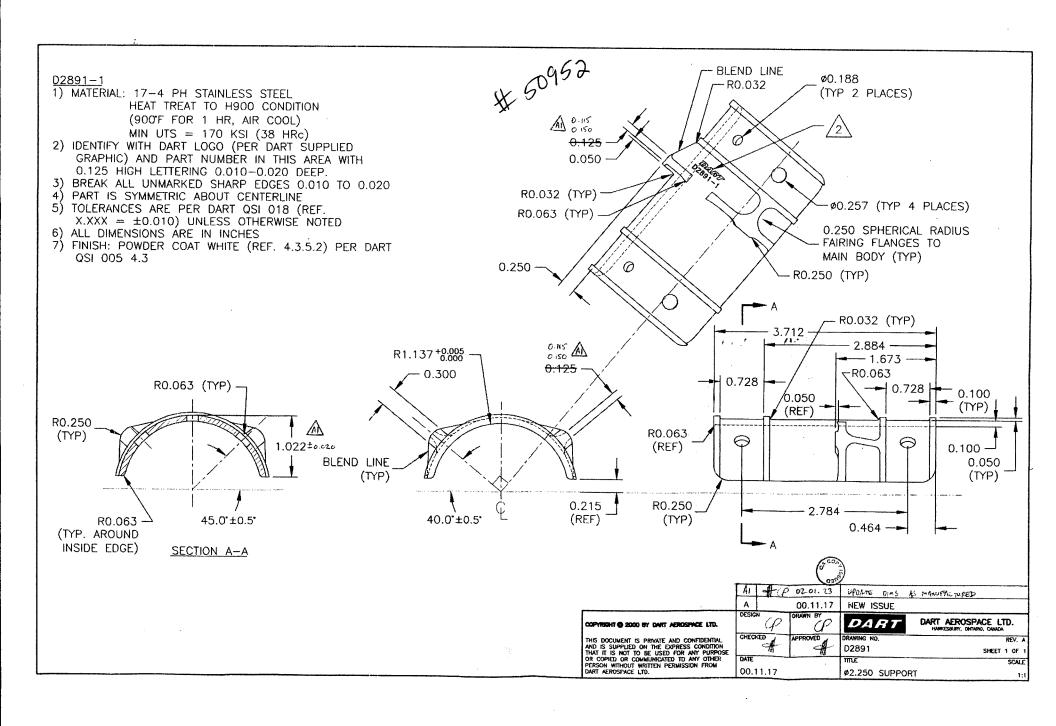
Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin	Primary Location	Last Location	Route Seq ID	Unit of Measure		Remaining Qty To Pick	Qty Issued	Date Issued	Status
DSK076RevA		Manufactured	No			110	Each	15.0000	10.0000			

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
MAT	15	 = -	
42244	1		
43384	4	$\sim 51/4$	
46923	10	DJ+69/67/29 _1	0

	Dart	Aeros	pace	Ltd
--	------	--------------	------	-----

W/O:			V	VORK ORDER CHAN	GES				. <u> </u>	
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Ca	tegory:	NCR	l: Yes N	lo DQ .	A:	Date:	
	Re	esolution:	Disposit	ion:	QA:	N/C Clo	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	MANCE	(NCR)	ı			
DATE	STEP	Description of NC	1		ection B	C: 0		cation	Approval	Approval
	0121	Section A	Initial Chief Eng	Action Description Chief Eng	1	Sign & Date	Secti	on C	Chief Eng	QC Inspector
			I							=
,										
					: 12			:		



Dart	Aeros	pace	Ltd
------	-------	------	-----

Dail Aci	ospace	Liu									
W/O:			W	ORK ORDER CHANGE	S		-	<u> </u>			
DATE	STEP	PROC	EDURE CH	CHANGE By Date			URE CHANGE By Date Qty Approval Chief Eng / Prod Mgr			Approval QC Inspector	
Part No		PAR #:									
	R	esolution:	Dispositi	ion:	QA: N/C	losed:		Date:			
NCR:	*	Wo	ORK ORI	DER NON-CONFORMA	NCE (NC	R)	1 1				
		Description of NC		Corrective Action Section	n B	Verifi	cation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	ion C	Chief Eng	QC Inspector		
				. //							
-											

DART AEROSPACE LTD	Work Order:	50950
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

		FIRST	ARTICLE IN	SPECTION	DIMENSI	ON SHEET	Ī	31"
			X First A	Article	Proto	type		
					Record	Actual Dim	ensions	
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
				HAAS Section	on	,		
AA	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AB	0.240	0.260		0.250	0,250	0.230	0.250	0.250
AC	0.115	0.150		0.127	0,127	0.124	0.125	1/25
AD	0.040	0.060		0.052	0.050	0.050	0.050	0.050
AE	0.010	0.020		0.020	0,020	0,020	10.02 <i>0</i>	0.020
AF	0.240	0.260		0.250	0,250	0.250	0.250	0.250
AG	0.290	0.310		0.300	0.300	0.300	0,300	0,300
AH	0.115	0.150		0.130	0.140	0.138	0,138	0.139
ΑI	0.454	0.474		0.459	0,400	0,460	0.459	0,460
AJ	2.779	2.789		2.782	2,782	2.782	2.783	2.783
AK	0.240	0.260		0.250	0,250	0,250	0250	0.250
AL	1.002	1.042		1.035	1.035	1,035	1,035	1.035
AM	0.053	0.073		0.063	0.063	0.063	0,063	0.063
AN	0.257	0.262		0.258	0.258	258	258	,258
AO	1.663	1.683		1,676	1.676	1,676	1.676	1.676
AP	0.053	0.073		0.063	0.0023	0.063	0,043	0.063
AQ	0.022	0.042		0,032	0032	0.032	0.032	0.032
AR	,							
AS	`							
AT								
	<u> </u>		Accept/Reject					
		\overline{z}					//	,
	Measured	by:	4			Date:	09/07/2	9
	Audited	l by: Å, A				Date:	09/08/0	06
D1-	A A					Detai	1 1	
Proto	type Appro	ovai:				Date:	<u> </u>	
Rev	Date	Change						Approved
Α	02.12.12	New Issue					/RF	A
В	08.04.21	Reformat				KJ.	JLM A	<i>\\</i> [][

Dart	Aeros	pace	Ltd
------	--------------	------	-----

		WO	RK ORDER CHANGI	ES	······································				
STEP	PROC	EDURE CHAI	IGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									·.
·									
	•							·	
:	PAR #:	_ Fault Categ	jory:	NCR: Y	es N	o DQ/	٨:	Date:	
R	esolution:	_ Disposition	:	_ QA: N/C	Clos	ed:		Date:	
	W	ORK ORDE	R NON-CONFORMA	NCE (N	CR)				
STED	Description of NC	<u> </u>				Verific	ation	Approval	Approval
SIEP	Section A	Initial Chief Eng	Action Description Chief Eng			Section	on C	Chief Eng	QC Inspector
		,							
									ty. v No.
		:PAR #: Resolution:W	STEP PROCEDURE CHAN PAR #: Fault Category Resolution: Disposition WORK ORDE STEP Description of NC Section A Initial	STEP PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Corrective Action Section Chief Eng Action Description Chief Eng Corrective Action Correctiv	PAR #: Fault Category: NCR: You Resolution: Disposition: QA: N/O WORK ORDER NON-CONFORMANCE (NOTED NOTED NO	STEP PROCEDURE CHANGE By PROCEDURE CHANGE NCR: Yes N PROSE NOR: Yes N PROCEDURE CHANGE Disposition: QA: N/C Clos WORK ORDER NON-CONFORMANCE (NCR) STEP PROCEDURE CHANGE Disposition: QA: N/C Clos WORK ORDER NON-CONFORMANCE (NCR) Corrective Action Section B Initial Chief Eng Chi	STEP PAR #: Fault Category: NCR: Yes No DQA Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Chief Eng Action Description Chief Eng C

	Work Order:	5095
DART AEROSPACE LTD		
Description: Ø2.250 Support	Part Number:	D2891-1
		Page 1 of 1
Inspection Dwg: D2891 Rev: A1		Fage 1 01 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

		FIRST A	X First A	Article	Protot	type		
					Record	Actual Dim	ensions	
Dim	Min	Max	Go/No Go Gauge	6.	7	8	9	10
			<u></u>	HAAS Sectio	n			
^ ^	0.188	0.193		0,188	0188	0.188	1188	1188
AA	0.188	0.260		0.250	0.250	0.250	1250	1250
AB	0.240	0.150		0.127	0,126	0.126	.127	112Ce
AC	0.113	0.060		0.050	0,050	0,050	(050	1050
AD	I	0.020		0.020	0.020	0.020	1020	1020
AE	0.010 0.240	0.020		0.250	0,230	0.250	1250	,250
AF	0.240	0.310	 	0.300	0.300	(3,3co)	300	1300
AG		0.310		0,13%	0.138	0.138	,/39	,139
AH	0.115	0.130		0.458	0,4(00	0.458	1457	0.458
Al	0.454	2.789		2.782	2.782	2.782	2.782	2-783
AJ	2.779	0.260		0,230	0,250	0,250	,250	,250
AK	0.240			@ 1,032	1,035	1,035	1.035	1.035
AL	1.002	1.042		0,063	0,063		,063	600
AM	0.053	0.073	<u> </u>	1258	1258	1258	.258	, 258
AN	0.257	0.262		1,678	1.677	1,676	1,67Ce	1,677
AO	1.663	1.683	 	0.063	,063	1063	,043	1063
AP	0.053	0.073			,032	,032	,032	. 032
AQ	0.022	0.042		0.032	1052	10,52		
AR					-	 		
AS							 	
AT		·	<u> </u>			 		
			Accept/Rejec	:t		1	1	_l
						Date	109/09	61
	Measure	by: D	17			Date	· 1 0//00/	
Γ	Audite	d by: 10.7	4		·	Date	: 09/08	106
L	7144110					 -	<u> </u>	
Proto	otype Appr	oval:				Date		
Rev	Date	Change					evised by	Approved
A	02.12.12	New Issue					J/RF	1911
B	08.04.21	Reformat				K	J/JLM CAN	<i>\\\\</i>
B	00.04.21	Iveronnar					(/	, ,

DART AEROSPACE LTD	Work Order:	50952
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev: A1		Page 1 of 1

		FIRST A	ARTICLE INS	F				
			X First A	Article	Protot	ype		
					Record	Actual Dim	ensions	
Dim	Min	Max	Go/No Go Gauge	11 🌸	12	13	14	15
				HAAS Sectio	n			1
AA	0.188	0.193		0188	0188	0.188	0.188	0.188
AB	0.100	0.260		0.250	0.247	1249	.249	1248
AC	0.240	0.150		0:1744	0.1240	.125	, 125	,120
AD	0.040	0.060		0.035	0.055	1055	0.053	.051
AE	0.040	0.020		0.020	0,020	0.020	0,020	1020
AF	0.240	0.260		0.250	0.250	0.250	0,250	,250
ĀG	0.290	0.310		,300	1300	,300	1300	,300
AH	0.115	0.150		0,139	0.140	1,40	140	140
Al	0.454	0.474		0.467	0.467	. 460	1466	1460
ΑJ	2.779	2.789		2.783	2.783	2.783	2.784	2.782
AK	0.240	0.260		0,250	0.250	0,250	0,250	,250
AL	1.002	1.042		1,033	1,032	1.033	1.034	1,034
AM	0.053	0.073		0.063	O.063	0.063	0,063	, o (e3
AN	0.257	0.262		0258	0,258	0258		
AO	1.663	1.683		1,670	1.076	1,676	1.676	1.67+
AP	0.053	0.073		0.063	0.063	0.063	0.063	063
AQ	0.022	0.042		0,032	0.032	0.032	0.032	,032
AR	0.022	- 0.0.1						
AS								
AT								
	<u> </u>		Accept/Rejec	t				
					, Lun			1
	Measured	l by:	\rightarrow			Date	09/08	/01
	MCGGGIO		1 1			7 - 5-4-	: 09/08	3/06
	Audite	d by: 🛮 🖽 .	A		<u> </u>	Date	:1 09/08	700
Proto	type Appr	oval:				Date	:	
	5-4-	Change				R	evised by	Approve
Rev	Date	Change New Issue					J/RF 1/A	-A
Α	02.12.12 08.04.21	New Issue					J/JLM A	(////

DART AEROSPACE LTD	Work Order:	50952_
Description: Ø2.250 Support	Part Number:	D2891-1
Inspection Dwg: D2891 Rev: A1		Page 1 of 1

		FIRST A	ARTICLE INS	PECTION	DIMENSIO	ON SHEET	Г ·		
			X First A	Γ	Proto				
					Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16 -	17	18	19	20 \$	
			ŀ	IAAS Section	on				
AA	0.188	0.193		1188	.188	.188	1188	1188	
AB	0.100	0.260		.749	0,247	1248	0.247	0.246	
AC	0.240	0.150		127	0.126	0.126	0,124	0,125	
AD	0.040	0.060		,047	0.055	0,054	0.054	0,054	
AE	0.040	0.020		1020	1020	.020	.020	.020	
AE	0.010	0.260		1250	1250	.250	,250	1.750	
AF	0.240	0.310		,300	300	.300	,300	1300	
AH	0.290	0.150		0.140	0.140	0140	1/39	1140	
	0.454	0.474		0,457		0,468	0.457	0,456	
Al	2.779	2.789		2.782	2.783	2.783	2,783	2.783	
	0.240	0.260		1250	,250,	1250c	1250	,250	
AK	1.002	1.042		1,035	1.034	1,034	1.035	1.033	
AL	0.053	0.073		1063	.063	.063	,063	1063	
AM	0.053	0.073		,258	258	.258	,258	.258	
AN	1.663	1.683	ļ	1.677	1.675	1,675	1.675	1,677	
AO		0.073		1063	,063	,063	1063	.oCe3	
AP	0.053 0.022	0.073	 	1032	.032	.032	1032	,032	
AQ	0.022	0.042	 	† · · · · · · · ·					
AR	<u> </u>								
AS				 					
AT	1		Accept/Reject						
<u></u>			- Acceptive)	1					
	Measured	by: D	$EP_{\mathcal{I}}$			Date:	<u> </u>	2	
Audited by: A						Date: 09/08/06			
Prototype Approval:						Date:			
					<u></u> -	R	evised by	Approved	
Rev	Date	Change					J/RF 14	1	
A	02.12.12	New Issue					J/JLM A	411	
B	08.04.21	Reformat					()	77	